

I/WE CLAIM:

1. A method for permanently attaching a substantially rigid lens to a substantially rigid plastic frame of goggles having ventilation, the frame including a shielding member contoured for shielding the eyes of a user, the method comprising steps of:
 - providing a molding device for molding the substantially rigid plastic frame;
 - placing the lens in a predetermined position with respect to the molding device, in which position a portion of the molding device overlaps a portion of the lens; and
 - forming the substantially rigid plastic frame with permanent engagement of the lens thereto using the molding device.
2. A method as claimed in claim 1 further comprising a step of providing a hollow space defined in a portion of the lens to be attached such that a portion of the substantially rigid plastic frame is filled into the hollow space defined in the lens during the frame forming step, thereby permanently engaging the lens.
3. A method as claimed in claim 2 wherein the hollow space in the lens is defined as a plurality of holes extending through the portion thereof which the portion of the molding device overlaps such that a plurality of studs formed together with the plastic frame in the forming step, extend through the

individual holes in each lens to permanently engage each lens to the substantially rigid plastic frame.

4. A method as claimed in claim 2 wherein the hollow space in the lens is defined as a groove formed in the portion thereof which the portion of the molding device overlaps, a distance between opposed walls of the groove at an opening thereof being smaller than a distance between the opposed walls at a bottom of the groove such that a projecting member formed together with the substantially rigid plastic frame in the forming step, is filled into the groove in each lens to permanently engage the lens to the substantially rigid plastic frame.
5. A method as claimed in claim 1 wherein a continuous portion of the molding device overlaps a continuous peripheral portion of the lens at both sides thereof such that the substantially rigid plastic frame is formed with opposed continuous walls, thereby defining a continuous channel between the opposed continuous walls configured to correspond to the peripheral portion of the lens, the continuous channel having a depth to permanently engage the annular peripheral portion of each lens.
6. A structural arrangement for attaching a lens to a frame of goggles having ventilation, the frame including a shielding member contoured for shielding the eyes of a user, the structural arrangement comprising:

a frame body made of a plastic material, the frame body defining an aperture receiving the lens therein and defining a plurality of ventilation passages for circulating air between the face of the user and the lens;

a plurality of retaining members integrally formed together with the frame body; and

the respective retaining members being configured to achieve permanent attachment of the lens to the plastic frame body during formation of the frame body.

7. A structural arrangement as claimed in claim 6 further comprising:

a hollow space defined in the lens; and

a portion of the frame body filled into the hollow space of the lens during formation of the frame body, thereby permanently engaging the lens.

8. A structural arrangement as claimed in claim 7 wherein the retaining members comprise first and second groups thereof, the respective first and second groups of the retaining members abutting opposed sides of the lens and having a plurality of studs extending between the respective first and second groups of the retaining members and crossing the lens through a plurality of holes defined as the hollow space in the lens, the studs being formed integrally with the respective first and second groups of the retaining members during the formation of the frame body.

9. A structural arrangement as claimed in claim 7 wherein the hollow space is defined as a plurality of holes extending through the lens and wherein the portion of the frame body filled into the hollow space is defined as a plurality of studs integrated with the frame body and extending through the respective holes.
10. A structural arrangement as claimed in claim 9 wherein each stud extending from the frame body through one of the holes in the lens comprises an enlarged end having a size greater than a diameter of the hole in order to permanently engage the lens between the frame body and the enlarged end thereof.
11. A structural arrangement as claimed in claim 7 wherein the hollow space in the lens is defined as a groove formed in the lens at one side thereof, a distance between opposed walls of the groove at an opening thereof being smaller than a distance between the opposed walls at a bottom of the groove such that a projecting member formed together with the frame body during the formation of the frame body, is filled into the groove in the lens to permanently engage the lens to the frame body.
12. A structural arrangement for attaching a substantially rigid lens to a frame of goggles having ventilation, the frame including a shielding member contoured for shielding the eyes of a user, the structural arrangement comprising:

a frame body made of a substantially rigid plastic material;

a plurality of retaining members integrally formed together with the substantially rigid plastic frame body; and

the respective retaining members being configured to achieve permanent attachment of the lens to the substantially rigid plastic frame body during formation of the frame body.

13. A structural arrangement as claimed in claim 12 wherein the retaining members comprise opposed continuous side walls extending into an aperture receiving the lens, thereby defining a continuous channel therebetween, the continuous channel being configured to correspond to a periphery of the lens for receiving the periphery of the lens therein, and having a depth sufficient to permanently engage the lens.
14. A structural arrangement as claimed in claim 13 wherein the frame body comprises a plurality of studs disposed in the continuous channel, each stud extending between the opposed side walls of the channel and crossing the lens through a plurality of holes defined in the lens.
15. A structural arrangement as claimed in claim 12 wherein the lens comprises a hollow space defined therein, and wherein the retaining members comprise a portion of the frame body filled into the hollow space of the lens during formation of the

substantially rigid plastic frame body, thereby permanently engaging the lens.

16. A structural arrangement as claimed in claim 15 wherein the hollow space is defined as a plurality of holes extending through the lens and wherein the portion of the substantially rigid plastic frame body filled into the hollow space is defined as a plurality of studs integrated with the frame body and extending through the respective holes.
17. A structural arrangement as claimed in claim 16 wherein each stud extending from the substantially rigid plastic frame body through one of the holes in the lens comprises an enlarged end having a greater than a diameter of the hole in order to permanently engage the lens between the frame body and the enlarged end thereof.
18. A structural arrangement as claimed in claim 15 wherein the hollow space in the lens is defined as a groove formed in the lens at one side thereof, a distance between opposed walls of the groove at an opening thereof being smaller than a distance between the opposed walls at a bottom of the groove such that a projecting member formed together with the frame body during the formation of the substantially rigid plastic frame body, is filled into the groove in the lens to permanently engage the lens.